

49

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	21972
<b>Description:</b> Bracket		<b>Part Number:</b>	D3264-1
<b>Dwg:</b> D3264 Rev. A		<b>Qty:</b>	<del>20</del> 21
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	04.11.25	<del>20</del> 21
2	MV	Cut blanks: 4.500" x 1.250" x 5.700" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) <b>Identify for D3264-1</b> Batch: <u>116391</u>	ML	05/02/23	21
3	MV	Machine as per Folio FA447 and Dwg D3264 <b>Identify as D3264-1</b>	ML	05/02/25	21
4	QC2	Inspect parts as they come off the CNC machine	ML	05/02/25	21
5	QC8	Second check	EL	05.02.25	21
6	MV	Deburr	ML	05/02/25	21
7	QC5	Inspect work to Step 6	EL	05.03.02	21
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05 03 03	21
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05 03 03	21
10	QC3	Inspect Powder Coat	CJ	05/03/04	21
11	ST	Identify and Stock <i>Identify with part; Batch # 116391 AFINE Print PERMANENT MARKER.</i>	CJ	05/03/04	21
12	AC	Cost / part <u>19.94</u>	Sgt	05.03.08	21
13	DC	Close W/O <u>19.96</u> Inspect Level 21	HJ	06.03.08	21

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED  
09/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		103101					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	21972
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.687	✓		Uem	
0.063	+/-0.010	0.064	✓		Uem	
0.125	+/-0.010	0.130	✓		Uem	
0.875	+/-0.010	0.881	✓		Uem	
0.062	+/-0.010	0.060	✓		Uem	
R0.03	+/-0.030	R0.03	✓		R-G	
R0.13	+/-0.030	R0.13	✓		R-G	
1.00	+/-0.030	1.013	✓		Uem	
0.125	+/-0.010	0.128	✓		Uem	
0.600	+/-0.010	0.598	✓		Uem	
R0.38	+/-0.030					cannot find dim.
4.000	+/-0.005	4.000	✓		Uem	
0.750	+/-0.010	0.747	✓		Uem	
<del>0.208</del>	+0.005/-0.000	0.194	✓		Uem	
0.194						
5.50	+/-0.030	5.500	✓		Uem	
1.27	+/-0.030					cannot find dim.
0.125	+/-0.010	0.127	✓		Uem	
0.063	+/-0.010	0.065	✓		Uem	
R0.25	+/-0.030	R0.250	✓		R-G	
4.27	+/-0.030	4.272	✓		Uem	
R0.30	+/-0.030	R0.30	✓		R-G	

Measured by:	ML	Audited by:	ER	Prototype Approval:	N/A
Date:	05/02/25	Date:	05.02.25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
04/04-07-08

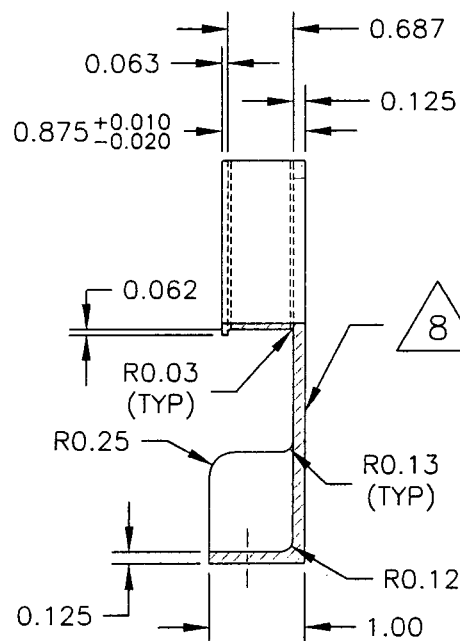
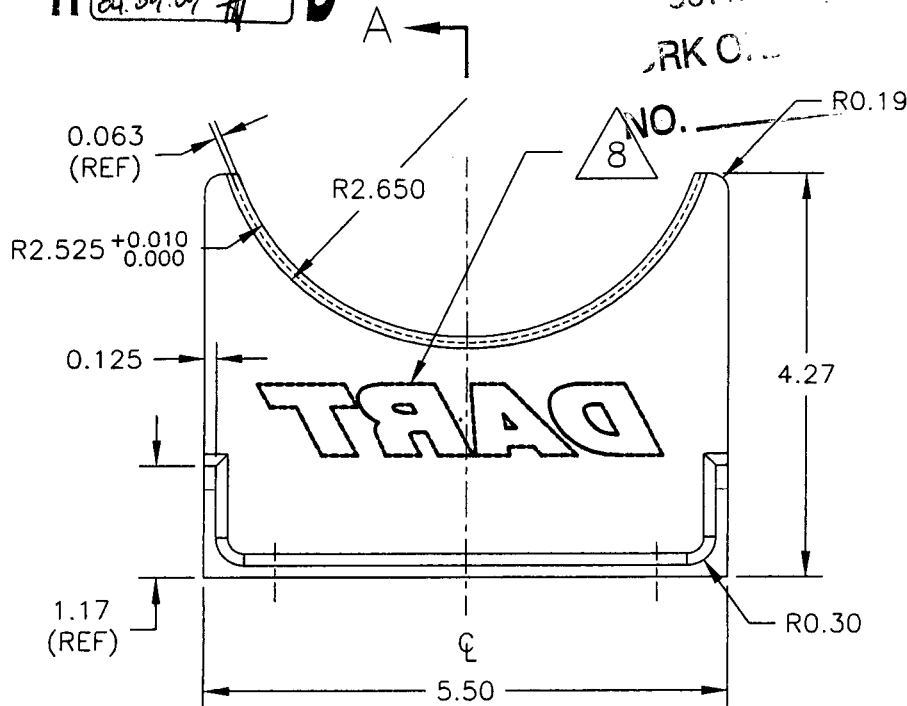


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

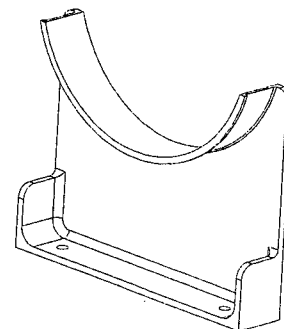
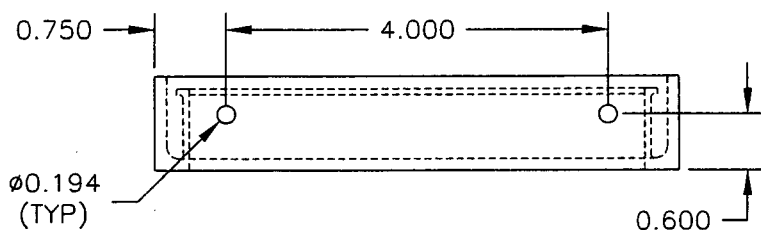
RELEASED  
04.04.09 #

NO AMEND  
OUT NOT

ARK O...



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC 6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY

UNCONTROLLED COPY  
SUGGESTED AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 21972

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 25, 2004  
10:55 am

Work Order No : 0021972  
Project Name : D3264-1  
Project For : WK449  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3264-1  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : ~~2028~~  
Amount Done : 0  
Start Date : 11-25-04  
Est Finish Date : 12-03-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00